

A METHOD OF INJECTION MOLDING OR EXTRUDING A POLYMER
COMPOSITION USING A LOW COMPRESSION SCREW

ABSTRACT OF THE DISCLOSURE

5 A method of injection molding or extruding a polymer composition having
a predetermined bulk density associated with particles, granules or pellets of the
polymer composition and a predetermined melt density when the polymer
composition is fully melted and compressed. The method of the invention
employs a screw having a volume compression ratio that is greater than or equal to
10 the ratio of the predetermined melt density to the predetermined bulk density of
the polymer composition and up to 1.25 X the ratio of the predetermined melt
density to the predetermined bulk density of the polymer composition.

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